

Work Order ID 132326

Thursday, May 07, 2015 9:14:22 AM

132326

Page 1

Item ID: D2646 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Cap
Start Date: 5/22/2015 Start Qty: 34.00 ***34*** Cust Item ID:
Required Date: 5/22/2015 Req'd Qty: 34.00 ***34*** Customer:
Reference:

Approvals: Process Plan: CL Date: MAR 07 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2646	Rev C								

100 PURCHASING 0.00
100
Purchasing Memo 0.00
Purchasing Issue P/O: 28374 1-Spin as per Dwg D2646 2-Material release
note required
Vendor: Sieg's Manufacturing

CL MAR 07 2015 34

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging Memo 0.00
Packaging Ensure Material Release Note is attached

34x 8p 15-05-15

120 QC6- Inspect dimensions to drawing 0.00
120
QC Memo 0.00
Quality Control

(34)

DAG
38
9-88

MAY 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Thursday, May 07, 2015 9:14:22 AM

132326

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

34

Cust Item ID:

34

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

1-Drill using DT8026 as per Dwg D2646.2-Open holes to .297 as per Dwg D2646.3-Deburr

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

Work Order ID 132326

Thursday, May 07, 2015 9:14:22 AM

132326

Page 3

Item ID: D2646

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Cap

Start Date: 5/22/2015 Start Qty: 34.00

34

Cust Item ID:

Required Date: 5/22/2015 Req'd Qty: 34.00

34

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160	<i>M 13/545.</i>					<i>34</i>	<i>0</i>	<i>15-6-14</i>	<i>2308</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>8:55</i> FINISH TIME: <i>9:25</i> OVEN TEMPERATURE:								
170	QC3- Inspect Part Finish	0.00							
170						<i>34x</i>	<i>0</i>	<i>15/06/04</i>	DAS 15 9-89
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Small Fab					<i>x3x</i>	<i>0</i>	<i>15/06/04</i>	
Small Fab	Memo	0.00							
Small Fab	Install inserts as per Dwg D2646								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 132326

Thursday, May 07, 2015 9:14:22 AM

132326

Page 4

Item ID: D2646

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Cap

Stop

NS2

Start Date: 5/22/2015 Start Qty: 34.00

34

Cust Item ID:

Required Date: 5/22/2015 Req'd Qty: 34.00

34

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

341 15-6-4 34 989

200

Identify as per dwg & Stock Location: FP001

0.00

200

Packaging

Memo

0.00

Packaging

LOCATION : FP001

x34 15/06/04

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCS JUN 04 2015

MCS JUN 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

Thursday, May 07, 2015 9:14:21 AM

Page 1

Work Order ID: 132326

132326

Parent Item: D2646

D2646

Parent Item Name: Aft Cap

Start Date: 5/22/2015

Required Date: 5/22/2015

Start Qty: 34.00

Required Qty: 34.00

Comments: IPP: G05.08.22Hole size revised in Step 5KJ/JLM
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130	AELS8-1032-130	Purchased		No		110	Each	4,364.000	2	68			
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AI S7-1032-130

Rivnut

all 15/06/01

ALS4-1032-130

Location

Loc Qty

Loc Code

FG

100

M1132312

168

121444

100

st549

4264

M128649

4264

D2646P

Purchased

No

180

Each

0.0000

1

34

D2646P

Aft Cap

34x 8015-05-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

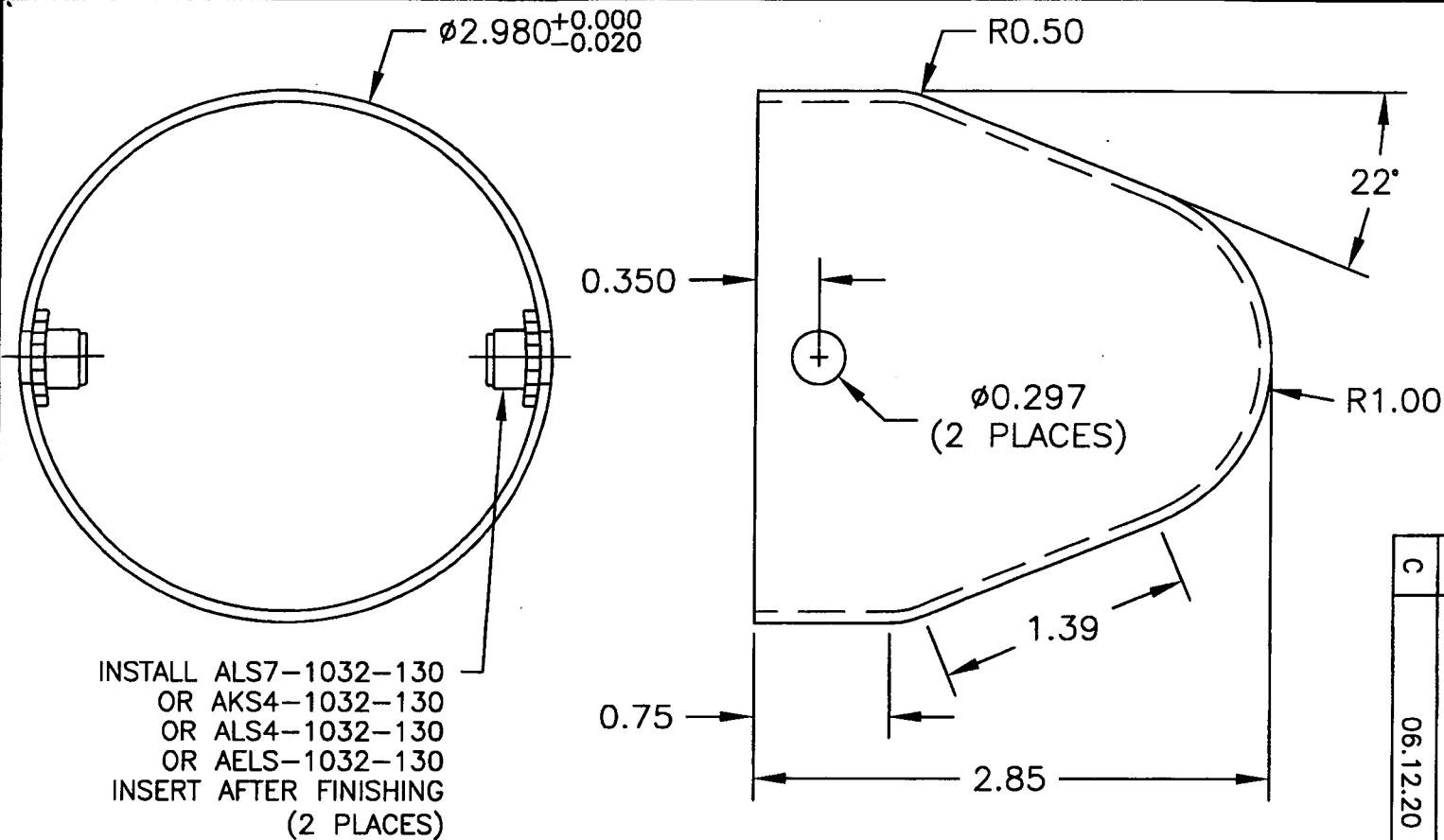
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OTHER : _____					



DESIGN	DS	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	PORT HADLOCK, WA
DATE	06.12.20		
A	97.03.25	NEW ISSUE	
B	05.04.01	CHANGE TO CLOSED INSERTS	
C	06.12.20	CHANGE TO OPEN ENDED INSERTS	

DRAWING NO.	D2646	REV. C
TITLE	AFT CAP	SHEET 1 OF 1
SCALE	1:1	



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CL15105107
W10.132326

RELEASED
07.02.12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28394**

Purchase Order Date 5/7/2015

PO Print Date 5/7/2015

Page Number 1 of 2

Order From :

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

VC-SIE001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FORM

Contact Name

Vendor Phone 604 530 7455

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	D2646P AS PER DWG D2646 REV. C B132325	Aft Cap	5/22/2015 Yes 5/22/2015		16.00 Each	\$6.70	\$107.20
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Line Total: \$107.20

2	D2646P AS PER DWG D2646 REV. C B132326	Aft Cap	5/22/2015 Yes 5/22/2015		34.00 Each	\$6.70	\$227.80
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Line Total: \$227.80

8015-05-15

Note:

5/7/2015



Sieg's Manufacturing Ltd.

Quality Metal Spinning & Metal Fabricating

6236 205 Street, Langley, BC, Canada V2Y 1N7

Phone: (604)530 7455 Fax: (604)530-7490

www.siegsmf.com

Packing Slip

Packing Slip No.:

45392

Date:

05/13/2015

Page:

1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 28394	Sold By: LOWEY, ARLA
Shipped By:	Ship Date: 05/13/2015
Tracking No.:	

Item No.	Unit	Description	Quantity	Backorder quantity
D2646	Each	Aft Cap	50	
34X 8015-05-15				
Comment:				



Sieg's Manufacturing Ltd.

6236 205 Street Langley, B.C. Canada V2Y 1N7

Ph#: (604)530-7455 fax#: (604)530-7490

arla@siegsmfg.com

INSPECTION REPORT

Date: May 13, 2015

Customer: Dart Areospace

Packing Slip: 45392

Part#:	Quantity	Material	Check holes	Insp. By.
D2646	50 34K.	14g 1100	N/a	AL

Notes:

Material Certification Attached: ____ YES ____



ThyssenKrupp Materials NA 19044 95A Avenue Surrey BC V4N 4P2

DELIVERY NOTE

SIEGS MANUFACTURING LTD.
3236 205 ST
LANGLEY BC V2Y 1N7



DATE:	01/06/2014
DOC. NO:	2402875712*
BOL. NO:	2402875712
ORDER NO:	1401788868
YOUR P/O:	1514
CUSTOMER NO:	10007550
Route:	B9M15
CONTACT:	Timothy Skidmore
TEL:	800-926-2600
FAX:	888-926-2600
EMAIL:	timothy.skidmore@thyssenkrupp.com

PST-1001-1682 OLD PST# R292133

We deliver at your own risk and account in accordance with our general delivery and payment terms.

ITEM	DESCRIPTION	NET QTY1 / QTY2	PACKAGE NO.
0010	ALFLR01243 1100 Aluminum - O Sheet 0.06300 X Width 48.0000 X Length 144 Nominal Chemistry/Act Physical Standard Packaging	100 PC 4,267.469 lb	1003901956 1003901957
	TAGNUMBER QUANTITY UOM VENDOR VENDORPO HEAT/LOT PCS		
	1003692716 74 PC SKANA ALU 5400197413 11A711 74		
	ROHS COMPLIANT;ASTM B 209 2010		
	1003793591 26 PC SKANA ALU 5400200310 11B224 26		
	ROHS COMPLIANT;ASTM B 209 2010		

Total Gross Weight

4517.469 lb

All items, not declared as partial delivery, are final quantities.

Delivery Terms: PPD gem. Incoterms 2000 Prepaid

CERTIFICATION OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products. The products we distribute are not hazardous in their received state.

For MSDS sheets go to www.copperandbrass.com. We hereby certify that the material above complies with the above specifications

John R Zambetti - Director of Quality Assurance

ThyssenKrupp Materials NA
Copper and Brass Sales Division
19044 95A Avenue
SURREY BC V4N 4P2
Tel.: +16048823493 Fax: +16048820686



Order number	Ord-pos	Del-pos	Part description	
Customer PO	PO date	Quantity	Customer Part	
MTR header	MTR type	Search criteria	Heat lot	Sample number
C8A/1401788868	000020	900001	1100 Aluminum - O Sheet 0.06300 X Width	
1514	12/18/2013	74 ST		
Att_001.PDF	NCAP	930230267220130003	11A711	
C8A/1401788868	000020	900002	1100 Aluminum - O Sheet 0.06300 X Width	
1514	12/18/2013	26 ST		
Att_002.PDF	NCAP	930235185120130004	11B224	

Delivery number
2402875712
Date
12/19/2013

SIEGS MANUFACTURING LTD.
6236 205 ST
LANGLEY V2Y 1N7
CANADA



Skana Aluminum Co
Rolling Mill - Certified Metal
Certification of Properties and Analysis

Physical test: **11A711** Aluminum Alloy: **1100** Temper: **-O-** Thickness: **.0630**

Tested For: **Copper and Brass Sales**

6156 PO No: **5400197413-R01**

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..		0.05	..	..	..	..	..	..		
Max Range	.95 Si	+Fe	0.20	0.05	..	..	..	0.1	..	0.05	

Coil Ref. No.	1	2	3	4	5						
Tensile Strength KSI	13.28	13.38	13.44	13.55	13.31						
Yield Strength KSI	4.34	4.25	4.46	4.58	4.47						
% Elong. in 2 in.	31.80	31.90	32.70	31.40	30.30						

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Remarks: Tested By: **RJD**

Certified Date: **10 Oct 2013**

Certified By
Lab Manager

Kenia Compton

RJD .063 X 48.000 MF 5/5

ITEM # ALFLR01243

MEETS/EXCEEDS ASTM B209-10 SPEC

BLANKS: COILS TO PRESSROOM

Thursday, October 10, 2013

Melted/Manufactured in USA

QF 824-1-1

Page 1 of 1

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

CstAr

Wgt.: 3,157.927 LB

Del.: 2402875712

CstOr 1514

Date 12/19/2013

John R. Zambetti

Skana Aluminum Company

Rolling Mill - Certified Metal

Certification of Properties and Analysis

Physical test: 11A711 Aluminum Alloy: 1100 Temper: -O- Thickness: .0630
 Tested For: Copper and Brass Sales 6156 PO No: 5400197413-R01

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..		0.05	..	..	..	..	..	..		
Max Range	.95 Si	+ Fe	0.20	0.05	..	..	..	0.1	..	0.05	

1	13.28	4.34	31.80	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.44	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

2	13.38	4.25	31.90	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

3	13.44	4.46	32.70	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

4	13.55	4.58	31.40	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.44	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

5	13.31	4.47	30.30	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

Remarks: Tested By: RJD Certified Date: 10 Oct 2013 Certified By: *Kenna Clampton*
 RJD .063 X 48.000 MF 5/5
 ITEM # ALFLR01243
 MEETS/EXCEEDS ASTM B209-10 SPEC
 BLANKS: COILS TO PRESSROOM

Thursday, October 10, 2013

Melted/Manufactured in USA QF 824-1-2

Page 1 of 2

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

CstAr

Wgt.: 3,157.927 LB

Del.: 2402875712

CstOr 1514

Date 12/19/2013

John L. Zambetti



Skana Aluminum Co
Rolling Mill - Certified Metal
Certification of Properties and Analysis

Physical test: 11B224 Aluminum Alloy: 1100 Temper: -O- Thickness: .0630

Tested For: Copper and Brass Sales

6156 PO No: 5400200310-R01

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Tl	Others	Al
Min Range	..		0.05	..	..	..	..	..	..		
Max Range	.95 Si	+ Fe	0.20	0.05	..	..	..	0.1	..	0.05	

Coil Ref. No.	1	2	3	4	5						
Tensile Strength KSI	14.10	14.06	14.04	14.06	14.14						
Yield Strength KSI	5.29	5.14	5.07	5.07	4.93						
% Elong. in 2 in.	30.80	30.40	30.70	31.30	32.30						

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Remarks: Tested By: RJD

Certified Date: 21 Nov 2013

Certified By
Lab Manager

RJD .063 X 48.000 MF 5/5

ITEM # ALFLR01243

MEETS/EXCEEDS ASTM B209-10 SPEC

BLANKS: COILS TO PRESSROOM

Thursday, November 21, 2013

Melted/Manufactured in USA

QF 824-1-1

Page 1 of 1

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

Del.: 2402875712

CstAr

CstOr 1514

Wgt.: 1,109.542 LB

Date 12/19/2013

Skana Aluminum Company

Rolling Mill - Certified Metal

Certification of Properties and Analysis

Physical test: 11B224 Aluminum Alloy: 1100 Temper: -O- Thickness: .0630

Tested For: Copper and Brass Sales

6156

PO No: 5400200310-R01

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..	..	0.05	..	..	..	..	..	..	..	..
Max Range	.95 Si	+ Fe	0.20	0.05	..	..	..	0.1	..	0.05	..

1	14.10	5.29	30.80	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

2	14.06	5.14	30.40	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

3	14.04	5.07	30.70	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

4	14.06	5.07	31.30	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

5	14.14	4.93	32.30	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

Remarks: Tested By: RJD

Certified Date: 21 Nov 2013

Certified By:
Lab Manager

[Signature]

RJD .063 X 48.000 MF 5/5

ITEM # ALFLR01243

MEETS/EXCEEDS ASTM B209-10 SPEC

BLANKS: COILS TO PRESSROOM

Thursday, November 21, 2013

Melted/Manufactured In USA QF 824-1-2

Page 1 of 2

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

Del.: 2402875712

CstAr

CstOr 1514

Wgt.: 1,109.542 LB

Date 12/19/2013

[Signature: John R. Zambetti]

COPPER AND BRASS SALES**MATERIAL TYPE****ALUMINIUM ALLOYS****PRODUCT DESIGNATION****1100 1350 3003 3004 3105 5005 5083 5086 5182 5454 6061 6063****"WARNING"**

SMALL CHIPS, FINE TURNINGS AND DUST MAY IGNITE READILY. EXPLOSIONPOTENTIAL MAY BE PRESENT WHEN:DUST OR FINES ARE DISPERSED IN THE AIR; FINE, DUST OR MOLTEN ALUMINUMARE IN CONTACT WITH CERTAINMETAL OXIDES; OR, CHIPS, FINES, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH WATER OR MOISTURE. KEEP AWAY FROM IGNITION SOURCE. USE EXPLOSION- PROOF VENTILATION. KEEP MATERIAL DRY.

INHALING LARGE AMOUNTS OF COPPER, MAGNESIUM OXIDE, MANGANESE OXIDE, AND ZINC OXIDE FUMES OR DUST MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS. CHRONIC OVEREXPOUSURE TO COPPER MAY CAUSE THICKENING OF THE SKIN; AND SKIN,TEETH,AND HAIR DISCOLORATION. CHRONIC OVEREXPOUSURE TO MANGANESE DUST CAN CAUSE CENTRAL NERVOUS SYSTEM DAMAGE,SCARRING OF THE LUNGS AND REPRODUCTIVE HARM IN MALES.TARGET ORGAN IS PRIMARILY THE LUNG,BUT REPEATED HIGH EXPOSURE CAN ALSO AFFECT THE LIVER.CHRONIC OVEREXPOSURE TO TIN DUST OR IRON OXIDE DUST/FUME MAY CAUSE LUNG SIDEROSIS.CHRONIC OVEREXPOUSURE TO SILICON DUST CAN CAUSE CHRONIC BRONCHITIS.

THIS PRODUCT ALSO CONTAINS LEAD AND CHROMIUM COMPOUNDS.LEAD IS KNOWN TO CAUSE REPRODUCTIVE TOXICITY AND IS A KNOWN CARCINOGEN.EXPOSURE TO CHROMIUM DUST OR FUME MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS AND KIDNEY AND KIDNEY AND LIVER DAMAGE.UNDER HIGH TEMPERATURES,HEXAVALENT CHROMIUM MAY BE PRODUCED,IF INTHE INSOLUBLE FORM,IT IS A CONFIRMED HUMAN CARCINOGEN. (CALIFORNIA PROPOSITION 65). IF COATED WITH OIL,MAY CAUSE SKIN IRRITATION/DERMATITIS BY CONTACT. WELDING FUME IS LISTED AS A POSSIBLE CARCINOGENIC TO HUMANS.READ THE ALUMINUM/ALUMINUM ALLOYS MATERIAL SAFETY DATA SHEET(MSDS) ON FILE WITH YOUR EMPLOYER BEFORE WORKING WITH THIS MATERIAL.

* If processing or recycling produces particulate,use exhaust ventilation or other controls designed to prevent exposure to workers. Examples of such activities include melting, welding,grinding,abrasive sawing,sanding and polishing.Any activity which abrades the surface of this material can generate airborne particulate.Use appropriate NIOSH approved respiratory protection (P95; P100 for lead with, quantitative fit testing required) if exposures exceed the permissible limits.

* The Occupational Safety and Health Administration (OSHA) have set mandatory limits on occupational exposures.

* Aluminum, in solid form and as contained in finished products presents no special health risk.

* Sold for manufacturing purposes only.This product can be recycled; contact your sales representative.

The Occupational Safety and Health Administration require employers to provide training in the proper use of this product.

For additional information, call or write to Copper and Brass Sales,22355 West Eleven Mile Road, Southfield, MI 48033,telephone248-233-5600, or visit our web site @ www.copperandbrass.com.

ALUMINUM LABEL NO.300-1088

ISSUED 10/01/2008